

Blue

Work Order ID 53295

October 30, 2009 1:16:45 PM



Page 1

Item ID: D206-642-441
Revision ID: F
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 29/10/2009 Start Qty: 1.00
Required Date: 09/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: RF Date: 09-10-30 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2650	Rev F
-------	-------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

SCRAP

Scrap 2

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Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

SCRAP

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

0.00



Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☒ M112507/M111999

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

> DD 9-11-3

BE 9-11-3

1 11/9/11/3

Scrap here

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-441 PAR #: Fault Category: Skill tubes NCR: (Yes) No DQA: Date: 05-11-12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 05-11-12

NCR: <u>53295</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-11-09	110	Employee noticed prior to installing the web, that the tube was NOT cut to length per drawing. This was noticed after inspection. R.C: L.A.	<u> </u> 05/11/12	Scrap; destroy; no replace New w/o will be issued. Record on job log for both parties, to ensure to verify work steps: draw dims, before each step.	<u> </u> 9/11/12 <u> </u> 05/11/12	<u> </u> 05/11/12	<u> </u> 05/11/12	<u> </u> 05-11-09

NOTE: Date & initial all entries

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Skidtubes								
Skidtubes	QC5	0.00	278010103				f		
	Memo Install D26801041 Nut plate as per Dwg								
130		0.00							
	QC								
Quality Control	Memo	0.00	278010103				f		

11/09/11/03 - Chemical conversion
- QC3

SCRAP

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Skidtubes	Skidtubes	0.00							
Skidtubes	Memo 1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D2654-7 web in place as per QSI015Ensure holes line upAllow 12 Hrs. cure time before cutting Start Date: <input type="checkbox"/> _____ Time: <input type="checkbox"/> _____ Finish Date: <input type="checkbox"/> _____ Time: <input type="checkbox"/> _____ A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> _____ Sikaflex expiry date: <input type="checkbox"/> _____	0.00							
150 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

Scrap

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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R ☐ Aluminum Rod ☐

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

165



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Scrap

SCRAP

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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 HandFinish	HandFinishing	0.00							
Hand Finishing	Memo Install D2680-041 Nut Plate as per Dwg D2650	0.00							
180 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
190 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

SCRAP

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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00							
	Hand Finishing								
205	Spray Painting per QSI005 4.2	0.00							
	SprayPaint	0.00							
	Spray Painting								
	Memo								
	PRIME GREY								
	SPRAY PAINT DELFLEET BLUE								
	CLEAR DELFLEET								
215	QC14- Inspect Spray Paint	0.00							
	QC	0.00							
	Quality Control								
	Memo								

Scrap

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Stop



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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☐ ☐Sikaflex expiry date: ☐

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ ☐Sikaflex expiry date: ☐6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4 ☐

Batch: _____

Scrap

SCRAP

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Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

SCRAP

MF 09-11-11

Picklist Print

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Page 1

Work Order ID: 53295

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 29/10/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB  Skidtube, 206 Skidtube		Manufactured	No			110	Each	13.0000	1.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

45898

13

D2646RevC

Manufactured No



Aft Cap

120

Each

13.0000 1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20208

0

43801

1

46327

4

48109

39

D2647RevF

Manufactured No



Cap

140

Each

23.0000 1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10773

23

43846

7

16

BE 9-11-3

Picklist Print

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Work Order ID: 53295



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2654-7RevE1		Manufactured	No			160	Each	2.0000	1.0000			
Web												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

52801

2

CCR264SS3-3

Purchased

No

170

Each

65.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

111548

111827

112314

65

38

1

26

SCRAP

2

Picklist Print

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Work Order ID: 53295



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			170	Each	476.0000	23.0000			

Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

51529

Main Warehouse

ST

36013

47112

48211

8

393

5

382

6

170

Each

75.0000

1.0000

D2680-041RevB1

Manufactured

No



Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

33061

44086

75

10

65

Picklist Print

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Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube



Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			230	Each	5,073.000	60.0000			
												
Insert												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

110511

5073

5073

AN960JD10L

Purchased

No



Washer

230

Each

5,735.000

62.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5735

101291

16

104885

153

105793

236

109632

420

110985

4910

Picklist Print

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Work Order ID: 53295



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube


Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416  Washer		Purchased	No			230	Each	4,591.000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

108161

110523

111279

111916

112514

109411

459

519

340

103

482

3149

0

CR3212-4-03



Cherry Rivet

Purchased

No

230

Each

292.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

111359

112314

292

92

200

Picklist Print

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Page 6

Work Order ID: 53295



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube


Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-1RevB  Plug		Manufactured	No			230	Each	359.0000	22.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

359

43990

8

45490

28

51530

50

D2651-3RevB

Manufactured No



O-Ring

230

Each

991.0000

22.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

991

43849

3

46114

988

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Page 7

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Work Order ID: 53295



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-15RevB		Manufactured	No			230	Each	22.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

17

51671

17

Main Warehouse

ST

17

30750

17

42233

17

D3535-23RevB

Manufactured No

230

Each

15.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

13

51618

13

Main Warehouse

ST

2

48156

2

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Work Order ID: 53295



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube



Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-37RevB		Manufactured	No			230	Each	18.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

51654

13

Main Warehouse

ST

47374

5

D3536-15RevA

Manufactured No



Gasket

30

Each

32.0000

1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

32

48159

6

51600

26

SCRAP

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Comments:

Start Date: 29/10/2009

Required Date: 09/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			230	Each	21.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

51609

Main Warehouse

ST

30754

7713

1

8

D3536-37RevA

Manufactured

No



Gasket

230

Each

20.0000

1.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

20

47375

7

51641

13

Picklist Print

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Parent Item Name: Replacement Skidtube



Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			230	Each	299.0000	6.0000			
												
Wearpad												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

48288

Main Warehouse

FP17

51624

51678

51679

Each

60.0000

1.0000

D3537-3RevC

Manufactured

No



Wearpad

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

30758

33881

35697

60

7

17

36

SCRAP

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Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS27039-1-08		Purchased	No			230	Each	2,947.000	2.0000			
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Screw



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST 2947

110467 188

110552 759

110835 2000

MS27039-4-06		Purchased	No			230	Each	75.0000	1.0000			
--------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



Screw



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST 75

109061 75

MS27039C1-08		Purchased	No			230	Each	962.0000	60.0000			
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SCREW



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST 962

19185 962

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F



NOTES:

MATERIAL: N/A

FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER

DART QSI 005 4.4

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: NONE

WEIGHT: N/A

WELD PER DART QSI 004

DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-2411-291 ADHESIVE PER DART QSI 015

) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

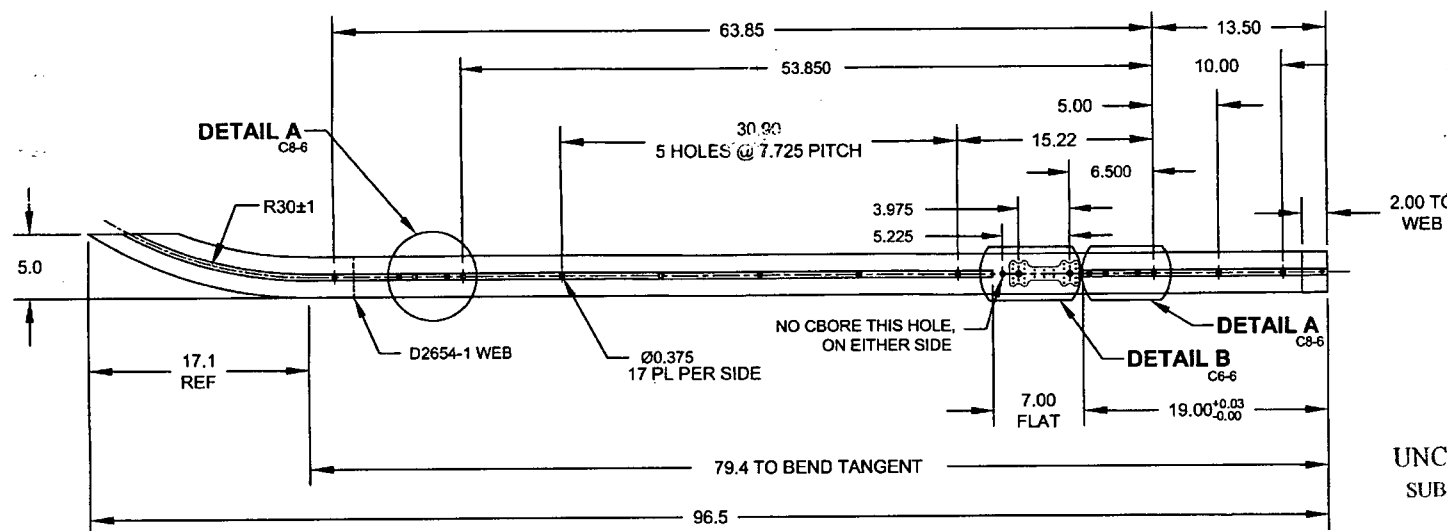
) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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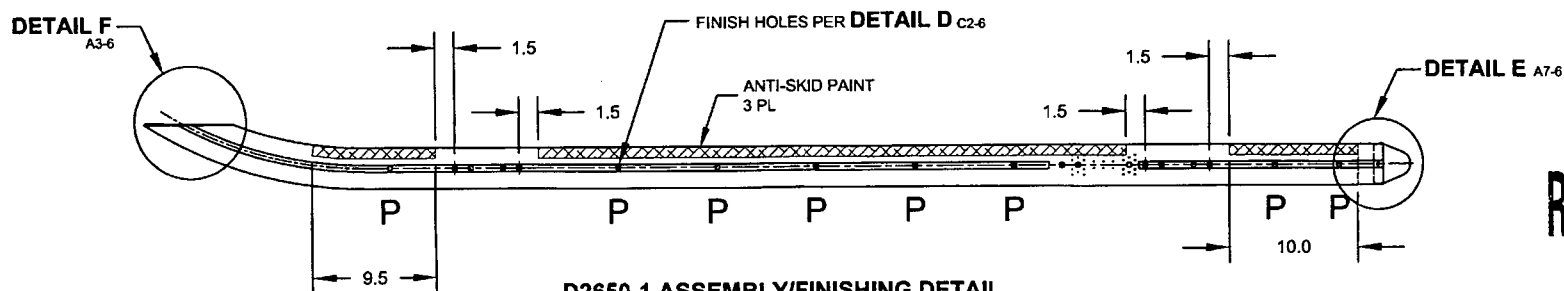
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
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DESIGN	DS		
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CHECKED			
MFG. APPR.			
DE APPR.			
DATE	08.08.08		

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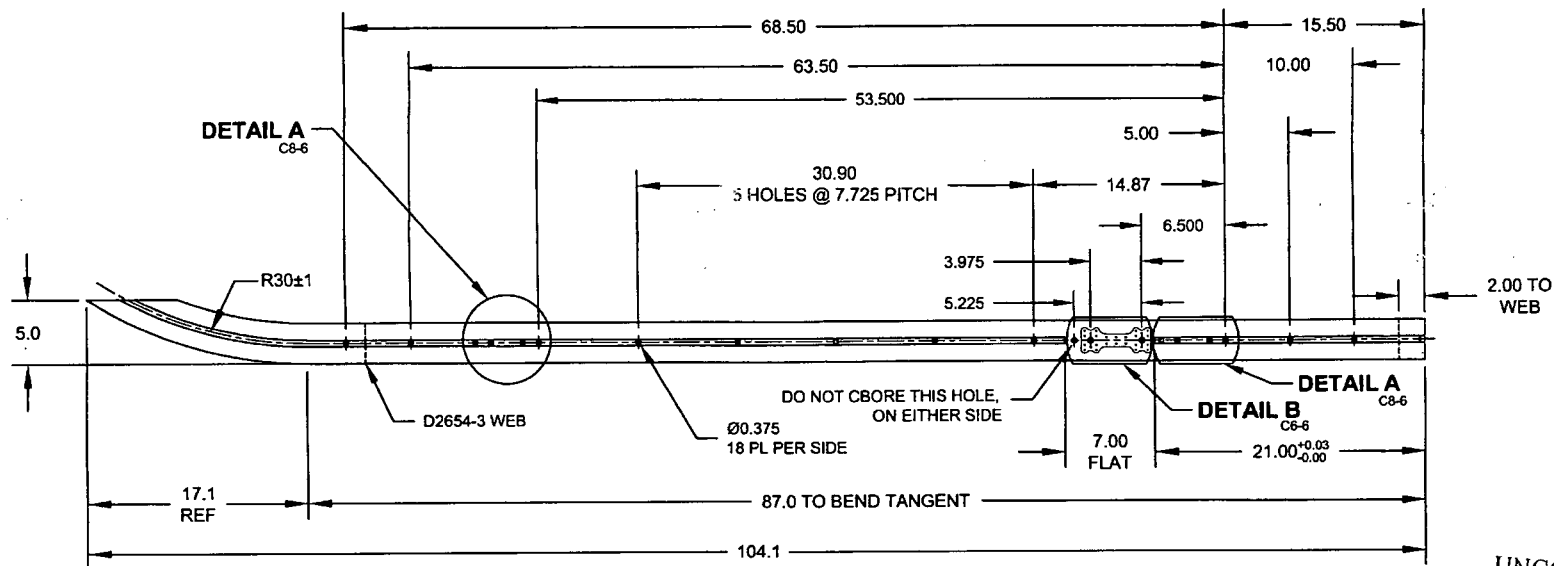
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D2650-1 ASSEMBLY/FINISHING DETAIL

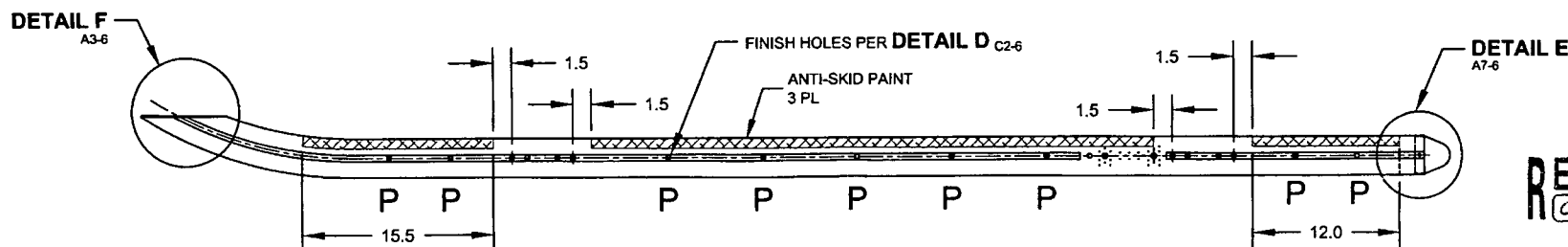
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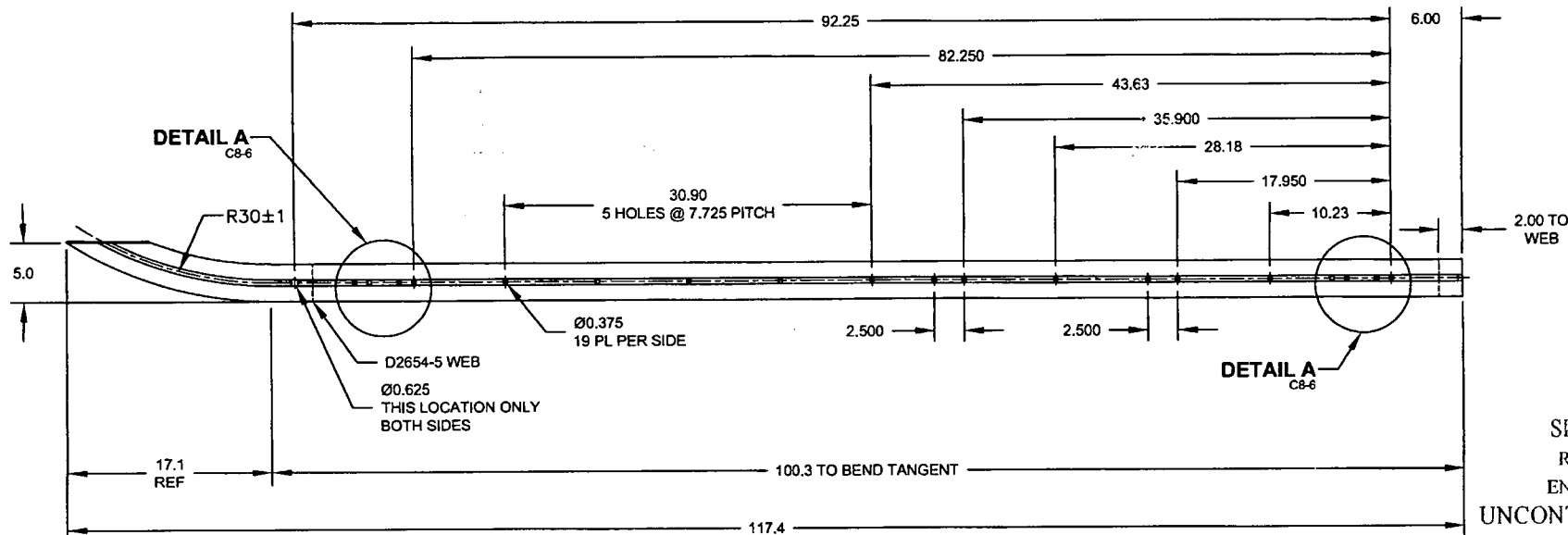
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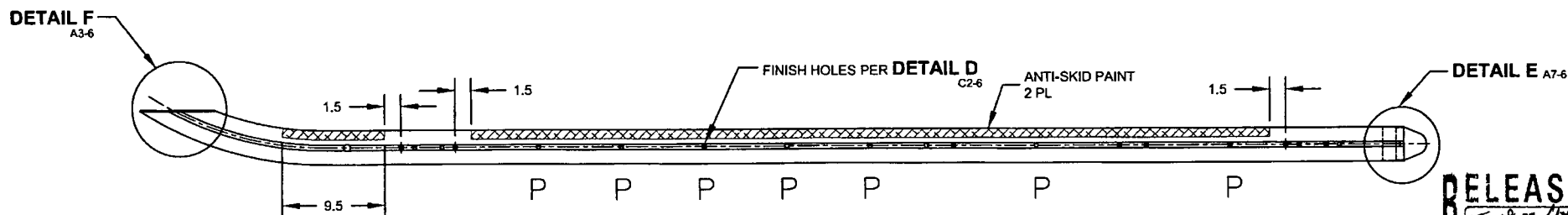
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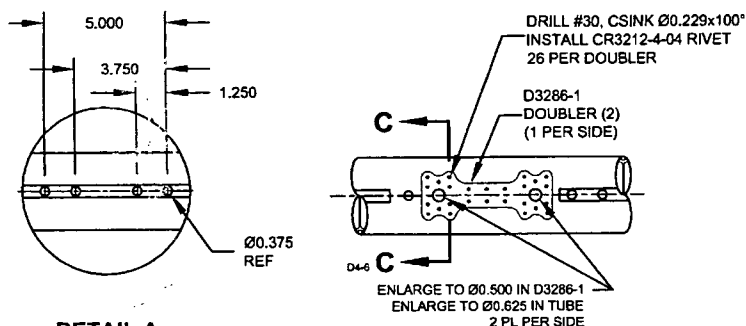
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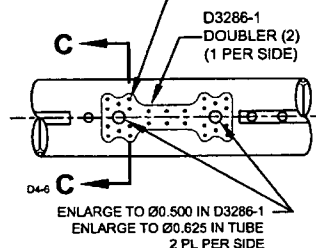
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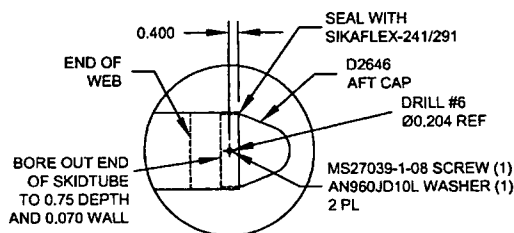
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DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

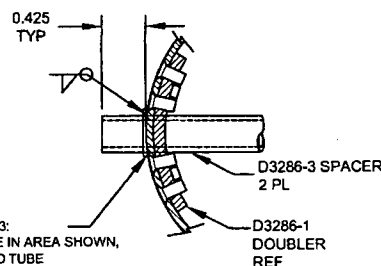


DETAIL B
SCALE 2X
C3-2
C3-3

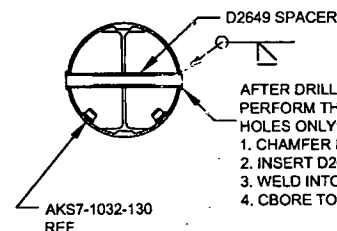


DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5

SECTION C-C C7-6
SCALE NONE

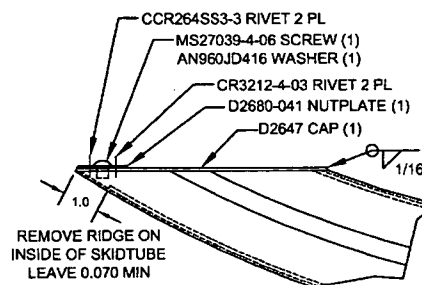


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP



DETAIL F
SCALE NONE
B6-2
B6-3
B6-4
B6-5




DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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